

Date: Tuesday, 15/08/2006 7:17:37 AM
User: Linda Lacelle

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 28161	
Estimate Number : 11038	
P.O. Number : N/A	Part Number : D2804044
This Issue : 15/08/2006 S.O. No. : NA	Drawing Number : D2804 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : R & D SM/MED FAB	Drawing Revision : B
Previous Run : 25711	Material : N/A
Written By : _____	Due Date : 08/09/2006 Qty: 8 Um: Each
Checked & Approved By : _____	
Comment : Est D 05.03.30 MS21043-3 was MS21042L3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28042	STA 155 Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	B26645 ✓

2.0	D28054	Stop
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-4	Stop	21306 B28246 Smp B28183 3ML ✓

3.0	D2809	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing

Pick:

Qty	Part Number	Description	Batch
	D2809	Bushing	27617 ✓ B27617 ✓

06/08/06

FAB 1

SMALL & MEDIUM FAB RESOURCE 1



SMALL & MEDIUM FAB RESOURCE 1

arm as per Dwg D2804

SB

06/09/06

NOTE: Date & Initial all entries must be made in accordance with the approved QA/CRCWO Rev 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

[illegible]

Date: Tuesday, 15/08/2006 7:17:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28161

Part Number: D2804044

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



06-09-06 *(8)*



Comment: INSPECT WORK TO CURRENT STEP

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-09-12 *(1)*

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06-09-12

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

MF 06/09/12 (8)

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt *07101189* ✓

AL 06/08/31

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut *0719099 10 mly*

07100218 6 mly

AL 06/08/31

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

07100993 4 NAS1515H3

Washer

06/09/05 (7)
AL 06/08/31 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/08/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28161

Part Number: D2804044

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R

LPS-3

Corrosion Spray

MIT395

MF 06/09/12 (8)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

MF 06/09/12 (8)

2-Assemble as per Dwg D2804.

MF 06/09/13 (8)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/13 (8)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 161

RB 06/09/14 (8)

MF 06/09/13

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RB 06/09/15 (8)

Job Completion



W 06/09/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

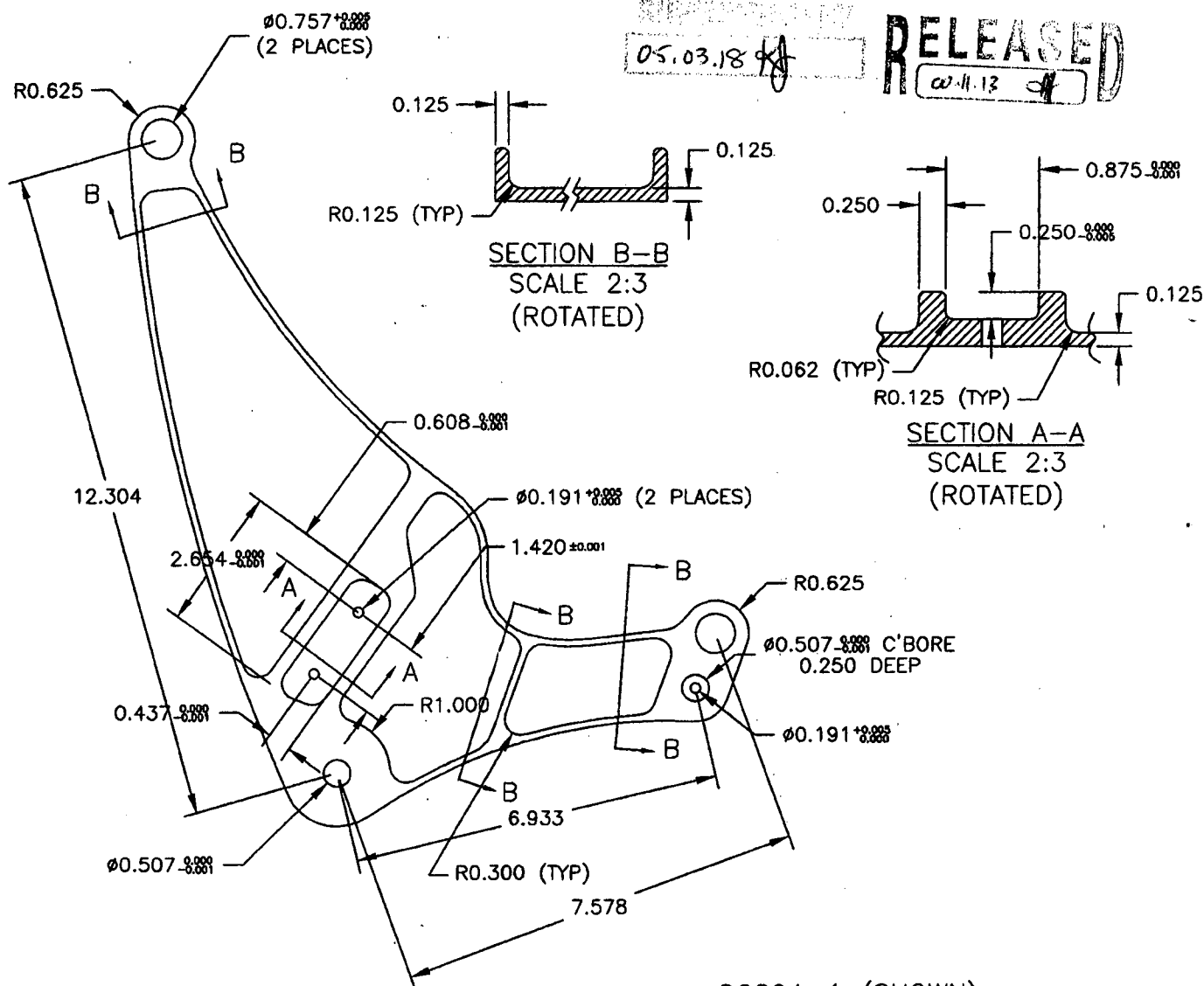
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 <i>CP</i>	



D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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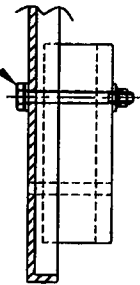
DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

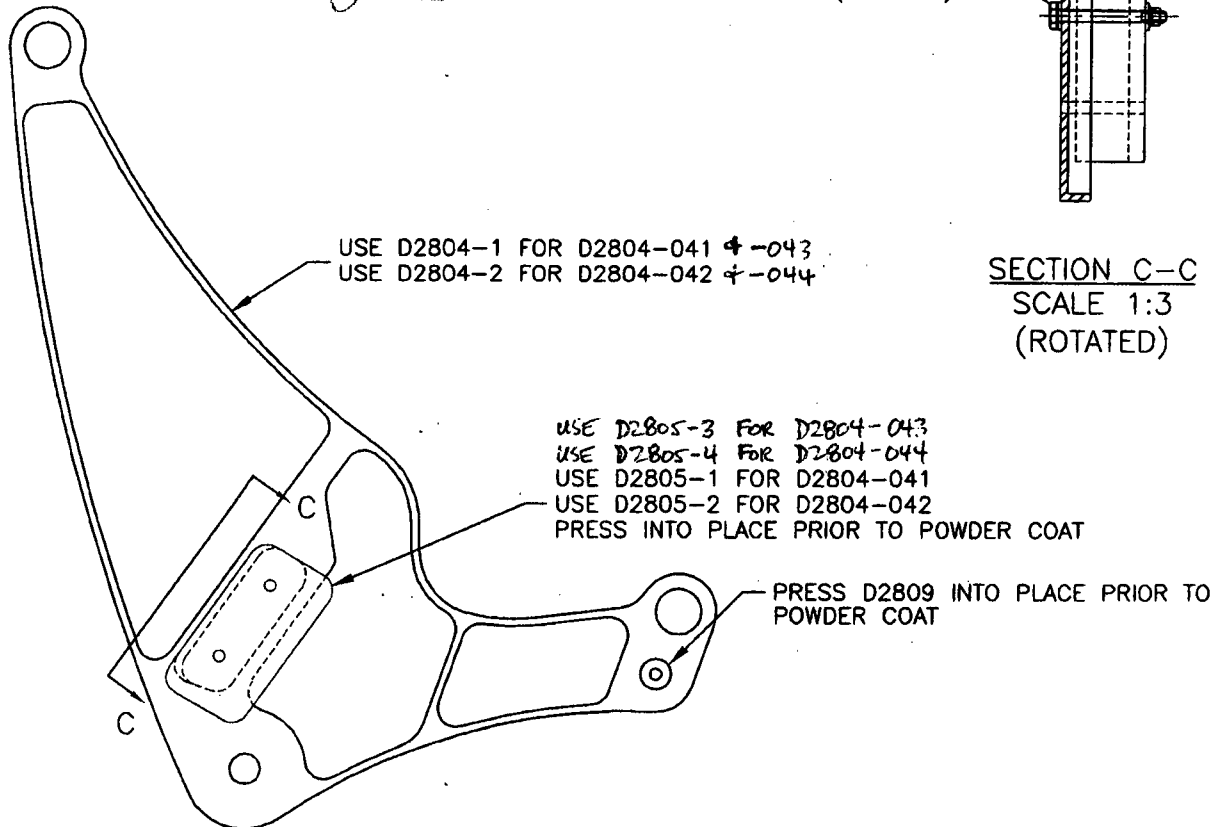
RELEASED
00.11.13 #**SUPERCEDED BY**

05.03.18 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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